



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-023
Job Sheet 169423



Part No: D412-698-023

Job Qty: 2 ea

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/13/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Great Slave Helicopters Ltd (CGREA01)

Accounting Office, 6285 Airport Way Kelowna, BC, V1V 1S1 Canada ph:(403) 286-2040 fx:(250) 765-0077.

Note: DWG REV F IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/13/17	0.00	0.00	Start Up Stores/Pkg-2		M.P.
110	Packaging	2 pcs		12/13/17	0.00	0.00	Packaging1-4		M.P.
120	QC	2 pcs		12/13/17	0.00	0.00	QC4		SmS
125	DC	2 pcs		12/13/17	0.00	0.00	DC		AT
130	Packaging	2 pcs		12/13/17	0.00	0.00	Packaging3-2		SmS
140	QC21-FG	2 Ea		12/13/17	0.00	0.00	QC21		fg 022 DEC 12 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3552-11 5020852	2	15	0	0
	D3594-043 5020845	2	7	0	0
	D3594-044 5020844	2	4	0	0
	D3594-5 5020853	2	5	0	0
	D3622-1 F158388	4	4	0	0
	MS20426AD4-4 5020896	4	1,916	0	0
	MS21073L5 5020893	2	6	0	0
	NAS1149D0516J 5020891	4	372	0	0

Part Specifications

Specifications could not be found.

Plex 12/11/17 1:01 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Job No: 169423 Mfg Date: 12/12/17 Start up Operation D412-698-023 Automatic Door Opener (fits LH or RH) S020918 DART AEROSPACE	Change No: _____ Operation: _____ Revision: _____ PART NO: _____	Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____
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Root Cause		DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Surge ☐ m ☐ x Pulled ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
Environment	☐	No Re-verfi	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐
Design	☐	Operator	☐	Crushing	☐	Countersink	☐	Off-set	☐
Doc/Data	☐	Offset/Setu	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐
Equip/Tooling	☐	Supplier	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐
Handling/Pre	☐	Training	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐
Material	☐	Use for Testing	☐						
Internal Transport	☐	Poor Information	☐						
Tribal Knowledge	☐	Rushing	☐						
LOA	☐	Product Improvement	☐						
Substation	☐	Process Improvement	☐						
Past Expiry Date	☐	Manufacturing Process	☐						
Misidentified	☐	Past Due	☐	OTHER : _____					

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: F

Date: 16.05.11